

Work Order ID 65025

Wednesday, January 05, 2011 2:44:05 PM

Page 1

Item ID: D412-704-041

Accept



Setup Start



Revision ID:

Item Name: Pedal Assembly (205/212/214/412)

Stop



Start Date: 1/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: 

Date: 11-01-5

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D412-704-041

Rev A

100

0.00



Small Fab

Small Fab

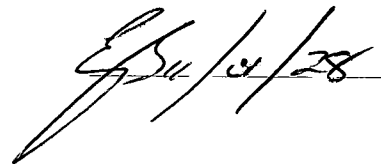
Memo

0.00

Small Fab

Assemble pedal as per Dwg D412-704-041

Tighten & Torque Bolts as per Dwg D412-704-041

 11/04/28 ①

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Sub 11/20

②

120

0.00




Pick Kit

Packaging

Memo

0.00

Packaging

 11/04/28 ③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Setup Start

Revision ID:

Stop

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Start Date: 1/5/2011 Start Qty: 1.00

Required Date: 1/14/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: 191

0.00



Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/02
MF
11-02-02

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries




Wednesday, January 05, 2011 2:44:08 PM

Parent Item Name: Pedal Assembly (205/212/214/412)

Required Date: 1/14/2011

Required Qty: 1.00

Comments: IPP Rev:B 05.01.28 Removed hardware on Step 2; Added Figures 1-3 KJ/RF
IPP Rev:C 06.03.08 Re-format EC
IPP Rev:D 07-03-20 Added Dwg D412-704-041 07-03-20 JLM
IPP Rev:E 07.05.02 Reformat EC
IPP Rev:F 08-10-08 as per revB DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-10A 		Purchased	No			100	Each	133.0000	1	1			
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST351				133					
				115877				1					
				116075				32		1			
				116400				100					
AN315-4R 		Purchased	No			100	Each	57.0000	1	1			
Nut													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST324				57					
				17566				57		1			
AN4-10A 		Purchased	No			100	Each	99.0000	1	1			
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST356				99					
				113422				1					
				114523				8					
				115835				40					
				116419				50		1			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Wednesday, January 05, 2011 2:44:08 PM

Page 2

Work Order ID: 65025

Parent Item: D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN4-12A Purchased No 100 Each 273.0000 2 2
Bolt

Location Loc Qty Loc Code

ST357 273
112314 73
115371 40
115422 160

AN4-13A Purchased No 100 Each 265.0000 1 1
Bolt

Location Loc Qty Loc Code

ST357 265
116191 265

*AN960JD10 NAS1149D0363J Purchased No 100 Each 8.0000 5 5
Washer 4 M116025 (5x)

Location Loc Qty Loc Code

ST 6
107715 6
ST335 2
105792 2

*AN960JD416 NAS1149D0463J Purchased No 100 Each 30.0000 11 11
Washer 4 M116304 (11x)

Location Loc Qty Loc Code

ST300 24
113288 24
ST356 6
115622 6

Wednesday, January 05, 2011 2:44:08 PM

Shop Packet Print

Page 2

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Wednesday, January 05, 2011 2:44:08 PM

Page 3

Work Order ID: 65025

Parent Item: D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00



AN960JD416L

NAS1149D0416J Purchased

No

100

Each

152.0000

3

3



Washer

4D M114884 (3x)



EP 5/11/07/28

Location

Loc Qty

Loc Code

ST346

152

106785

2

110153

150

D3204-041

Manufactured

No

100

Each

3.0000

1

1



Release Pedal Assembly



EP 5/11/01/28

Location

Loc Qty

Loc Code

ST197

3

60509

3

D3205-1

Manufactured

No

100

Each

3.0000

1

1



Pedal Bracket



EP 5/11/01/28

Location

Loc Qty

Loc Code

ST197

3

55731

3

D3205-3

Manufactured

No

100

Each

5.0000

1

1



Back Plate



EP 5/11/01/28

Location

Loc Qty

Loc Code

ST197

5

47491

5

D3206-1

Manufactured

No

100

Each

8.0000

1

1



Pedal Arm



EP 5/11/01/28

Location

Loc Qty

Loc Code

ST197

8

55732

8

Wednesday, January 05, 2011 2:44:09 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Wednesday, January 05, 2011 2:44:09 PM

Page 5

Work Order ID: 65025

Parent Item: D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

MS24694-S102

Purchased

No

100

Each

53.0000

1

1



Screw



Ep 5/10/28

Location

Loc Qty

Loc Code

ST288

50

114382

50

ST289A

3

113644

3

1

MS9519-10

Purchased

No

100

Each

35.0000

1

1



Bolt



Ep 5/10/28

Location

Loc Qty

Loc Code

ST297

35

100290

35

1

AN3-6A

Purchased

No

120

Each

176.0000

2

2



Bolt



U

Location

Loc Qty

Loc Code

ST351

176

114941

126

116191

50

m114941

AN960JD10L

NAS1149D0332J

Purchased

No

120

Each

0.0000

4

4



Washer



m11644 U

Wednesday, January 05, 2011 2:44:09 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, January 05, 2011 2:44:09 PM

Page 6

Work Order ID: 65025

Parent Item: D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)



Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

120

Each

2,544.000

1

2



Nut



1/11/2011

Location

Loc Qty

Loc Code

ST300

2544

114784

9

115835

831

116373

4

116391

900

116540

800

115835

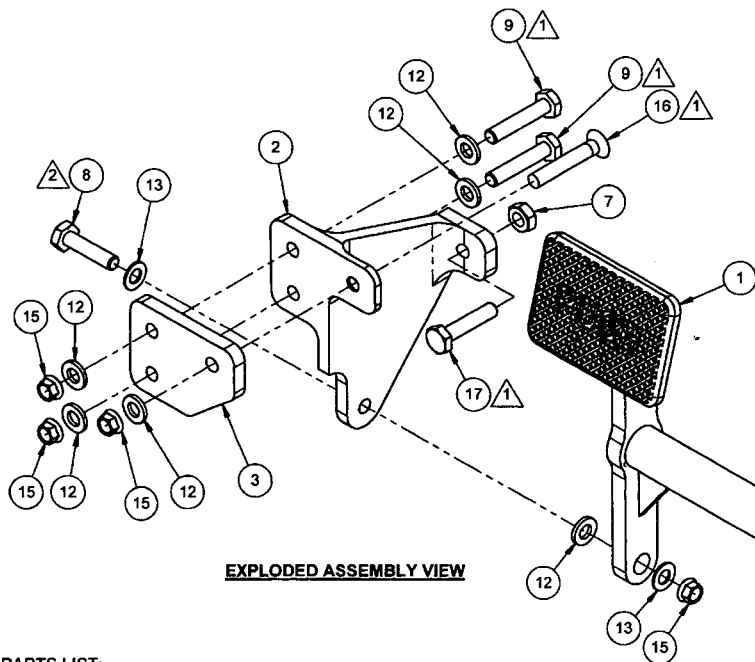
W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



EXPLODED ASSEMBLY VIEW

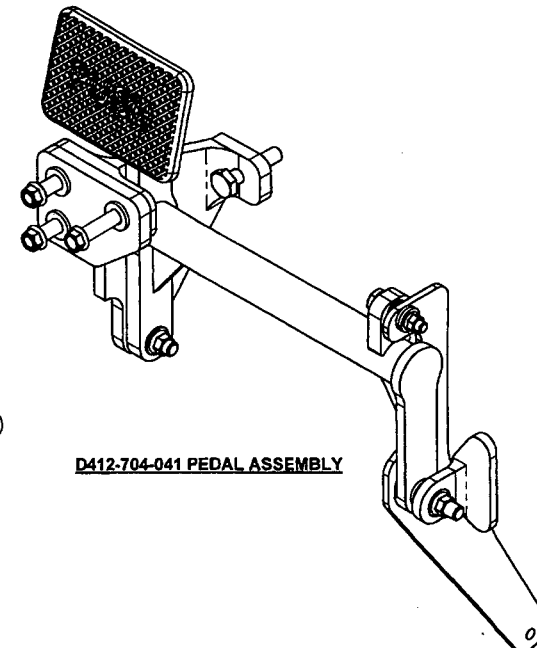
PARTS LIST:

ITEM	QTY	P/N	DESCRIPTION
-	X	D412-704-041	PEDAL ASSEMBLY
1	1	D3204-041	PEDAL WELDMENT
2	1	D3205-1	PEDAL BRACKET
3	1	D3205-3	BACK PLATE
4	1	D3206-1	PEDAL ARM
5	1	D3209-041	BRACKET ASSEMBLY
6	1	AN3-10A	BOLT
7	1	AN315-4R	NUT
8	1	AN4-10A	BOLT
9	2	AN4-12A	BOLT
10	1	AN4-13A	BOLT
11	5	AN960JD10	WASHER
12	11	AN960JD416	WASHER
13	3	AN960JD416L	WASHER
14	1	MS21042L3	NUT (OR MS21042-3)
15	5	MS21042L4	NUT (OR MS21042-4)
16	1	MS24694-S102	SCREW
17	1	MS9519-10	BOLT
N/A*	2	AN3-6A	BOLT
N/A*	4	AN960JD10L	WASHER
N/A*	2	MS21042L3	NUT (OR MS21042-3)

* SHIPPED LOOSE WITH -041 KIT (NOT PRE-ASSEMBLED AT DART)

NOTES:

1. INSTALL IDENTIFIED FASTENERS LOOSE (HAND TIGHTEN ONLY).
2. TIGHTEN IDENTIFIED FASTENERS UNTIL SNUG. ENSURE THAT PARTS CAN STILL ROTATE.
3. TORQUE IDENTIFIED FASTENERS TO 15-25 in-lbs (1.7-2.8 N-m).



D412-704-041 PEDAL ASSEMBLY

RELEASED

07.01.23

A	07.01.23	NEW ISSUE	DESCRIPTION
REV	DATE		
DESIGN	DRAWN BY		
C.B.	C.B.		
CHECKED	APPROVED		
CE			
DATE	07.01.23	TITLE	SCALE
		PEDAL ASSEMBLY	1:2
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DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D412-704-041

REV. A
SHEET 1 OF 1